

Friday, 01/08/2008 3:32:34 PM
Julie Lecocq

Process Sheet

Job Number : CU-DAR001 Dart Helicopters Services
 Estimate Number : 40977
 P.O. Number :
 This Issue : 01/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 40316
 Drawing Name : TUBE
 Part Number : D37695
 Drawing Number : D3769 REVA
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 21/08/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUL 08.8.05
 Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC

Additional Product

Job Number:



SCRAP

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W065

6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 1.7579 f(s)/Unit Total: 35.1582 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M102877

SAP

08/08/14

20

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3769

2-drill holes thru on both ends of tube as per dwg D3769

3- deburr

SAP

08/08/14

20

MWE

08/08/16

RD/MP 08/08/17

PTU

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

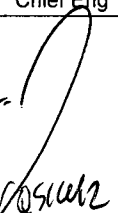
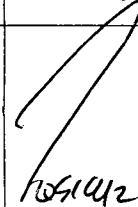
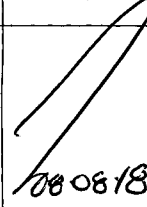


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3769-5 PAR #: N/A Fault Category: Prod / Pass' med & small NCR: Yes No DQA: D Date: 28/10/31
D412-769-043/044 QA: N/C Closed: 10/11/04 Date: 08.11.04

NCR: 40977		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-18	20	Holes are 0.075" off center on the total length. Total length is good & hole spacing is good. Holes are 0.425" from one end, & 0.600" from the other & supposed to be 0.5" P.C. In correct zero to start drilling. Operator never on set-up.		Identify the 20 scrap parts for this W/O, and can be used for shorter tube assemblies make Part 3770-1 B42879 201412	SB	08/10/23		

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 40977

Part Number: D37695

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MK 08-10-20

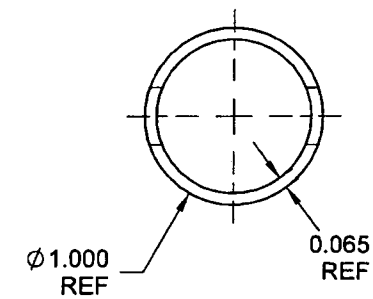
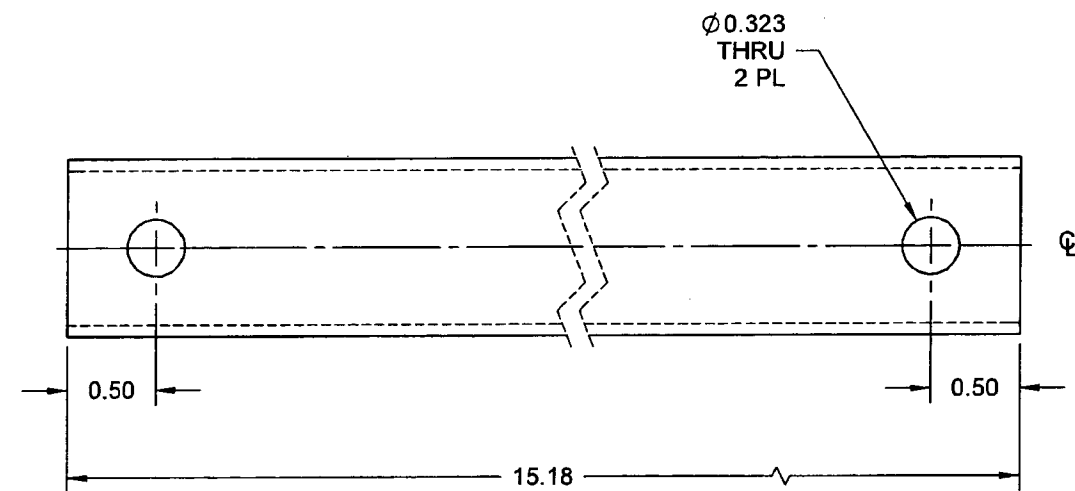
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

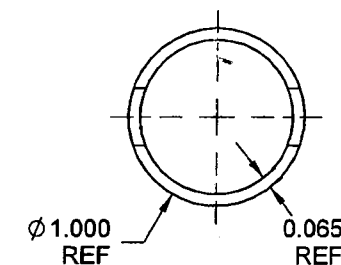


D3769-3 TUBE

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08.06.14

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NO. 40977

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DATE 08.06.04			

8

7

6

5

4

3

2

1

D

D

C

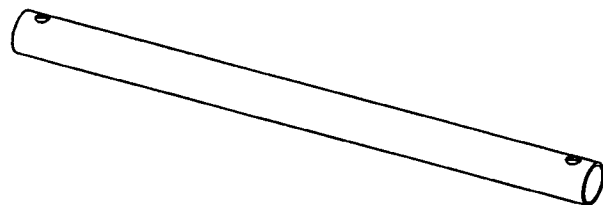
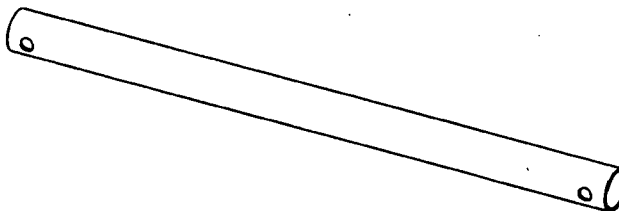
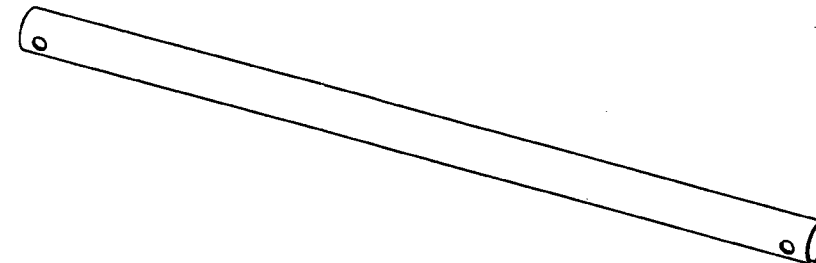
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B




B

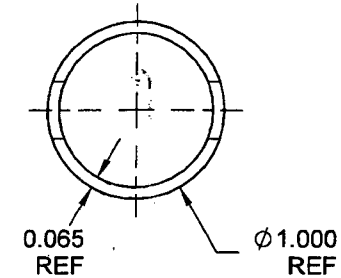
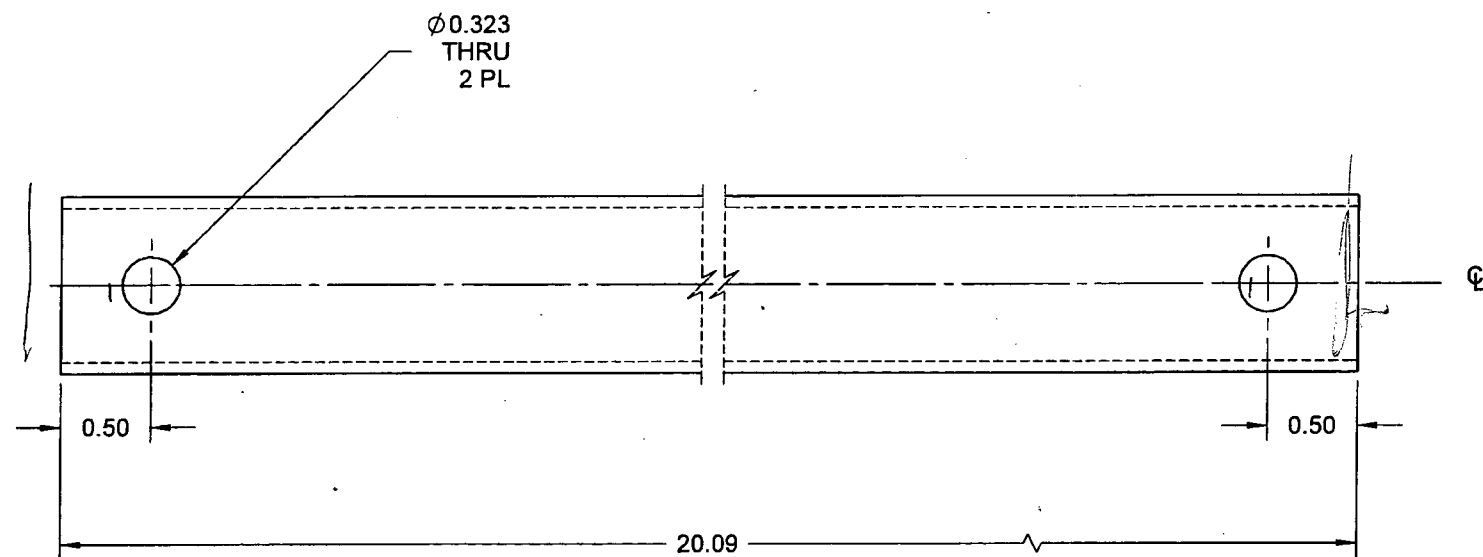
A

A

**D3769-1 TUBE****D3769-3 TUBE****D3769-5 TUBE****RELEASED**
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WORK ORDER
NO. 110977**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
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